



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5336-043
Job Sheet 180064



Part No: D5336-043

Job Qty: 1 ea

Part Name: Basket Lid Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 4,6,7,8 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Large Fab-6		3073266
100	Large Fab	1 pcs	7/13/18	7/13/18	0.00	6.59	Large Fab 1		18-07-25
110	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC9		18-07-25
120	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC5		18-08-07
130	Powdercoat	1 pcs	7/13/18	7/13/18	0.00	0.13	Powdercoat4		18-08-07
140	HandFinish	1 pcs	7/13/18	7/13/18	0.00	0.90	HandFinish3		18-08-07
150	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC3		18-08-07
160	Packaging	1 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-2		18-08-09
170	QC21-SA	1 Ea	7/13/18	7/13/18	0.00	0.00	QC21		21 AUG 09 2018

Part Op 100 - 1- Assemble ribs , weld as per dwg D5336 using DT10196 2- Weld hinge (2) and locking brackets as per dwg
Descriptions: D5336 ***inspect before welding mesh*** 3- Cut mesh as per dwg D5334-3 4- Tack weld mesh on basket as per dwg
D5336 ***Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

130 - *** Mask holes and sides of hinge prior to powdercoat*** Start Time: 10:30 am Oven Temperature: 320°C

Finish Time: 10:30 am 11:00 am

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4016-3	Hinge Half, Lid	2 Ea (2 ea)	90-Start up Operation	3073266
D5332-043	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	180824
D5332-11	Rib	1 Ea (1 ea)	90-Start up Operation	3064924
D5332-15	Rib	1 Ea (1 ea)	90-Start up Operation	3064736
D5332-17	Rib	2 Ea (2 ea)	90-Start up Operation	3089147
D5332-7	Rib	1 Ea (1 ea)	90-Start up Operation	3064984
D5332-9	Rib	1 Ea (1 ea)	90-Start up Operation	3065007
D5333-1	Locking Bracket	1 Ea (1 ea)	90-Start up Operation	180824
M304EX0.75-16F	Expanded Metal Flat SS	4.8000 sf (4.8 ea)	90-Start up Operation	3046611

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4016-3	2	40	0
	D5332-043	1	7	0
	D5332-11	1	3	0
	D5332-15	1	3	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D5332-17	2	0	0
D5332-7	1	3	0
D5332-9	1	3	0
D5333-1	1	5	0
M304EX0.75-16F	5	903	0

Part Specifications

Specifications could not be found.

Plex 6/28/18 9:59 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order: _____	DISPOSITIC Re Use Suspected Unapp
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
Description Work Order Deviation	

--

DART
AEROSPACE

Container No: S096103

Part: D5336 - 043

Job No: 180064

Serial No/Batch: S096103

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 832-6200
Email: sales@dartero.com
www.dartaerospace.com

Date: 07/25/18

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				